

September-25-13 9:20:01 AM

Item ID: D3016-17

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Gusset

Start Date: 9/11/13 **Start Qty:** 40.00

40

Cust Item ID:

Required Date: 10/02/13 **Req'd Qty:** 40.00

40

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: MLJ Date: 13-09-25 Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3016	Rev A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D3016 Dwg Rev: A Prog Rev: A 2-
Deburr if necessary

0.00

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

Quality Control

0.00

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

Quality Control

0.00

Work Order ID 106749

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Accept

N900040100Setup Start ***NS1***

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Item Name: Gusset

Start Date: 9/11/13 Start Qty: 40.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging					40	EL	13-9-27	
Packaging	Memo	0.00							
Packaging	Identify and bag with light oil (Vactra oil #2), then Stock *****STOCK IN LARGE FAB***** Location: <u>W/A 001</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

*JA / Rm 13/09/30**AB0927*

Picklist Print

September-25-13 9:20:04 AM

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Work Order ID: 106749

106749

Parent Item: D3016-17

D3016-17

Parent Item Name: Gusset

Start Date: 9/11/13

Required Date: 10/02/13

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP B03.05.09ReformatKJ/RF
IPP Rev:C 08-04-11 now made on water jet DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M4130NS.049		Purchased			No	100	sf	120.5903	0.0173	0.72842			
M4130NS 049									**	<u>1.0</u>			<u>JmB-09-25</u>

4130 Sheet .049

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT020	120.590263	
11612	4.2	
123049	17.340263	
124283	99.05	

124283



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3016	REV. A SHEET 1 OF 3
DATE 01.05.18		TITLE SEAT FRAME ASSEMBLY	SCALE NTS
A	01.05.18	NEW ISSUE	

QTY	PART NUMBER	DESCRIPTION	MATERIAL
X	D3016-041	SEAT FRAME ASSEMBLY	N/A
1	D3016-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3016-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3016-5	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
2	D3016-7	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
1	D3016-9	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-11	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-13	BRACKET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-15	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-17	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3020-1	FITTING	N/A

NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

106749 MLS
13-09-16

DEO ATTACHED

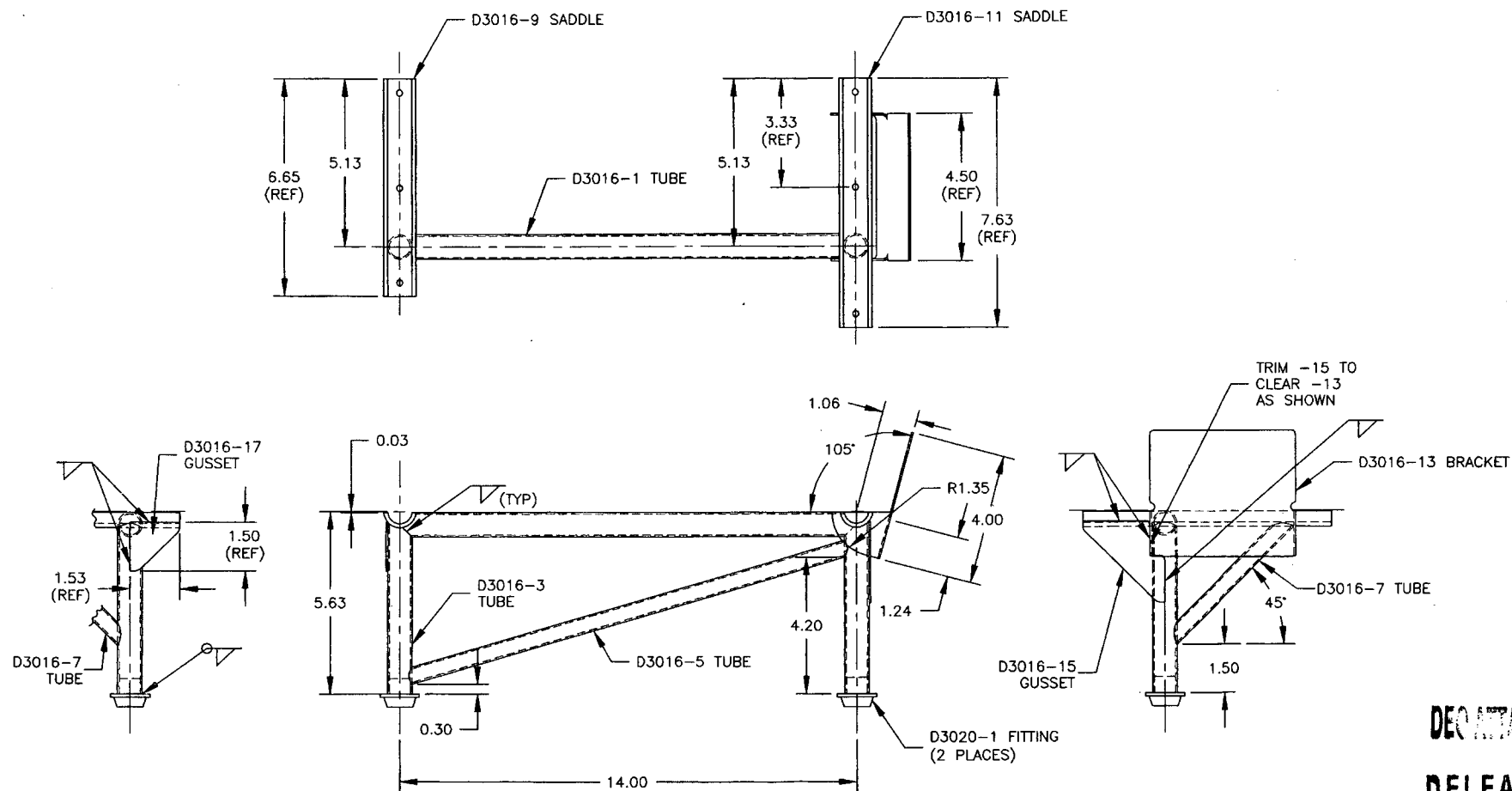
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106749

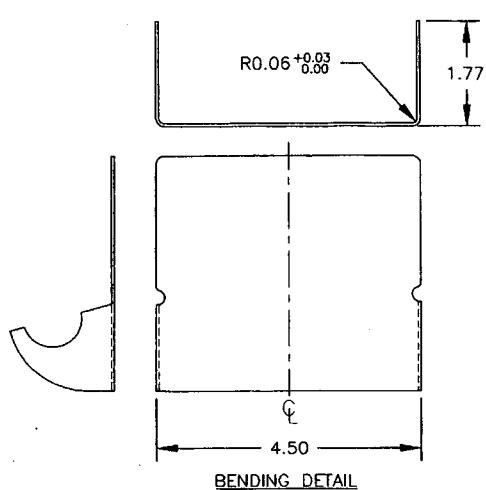
D3016-041 SEAT FRAME ASSEMBLY



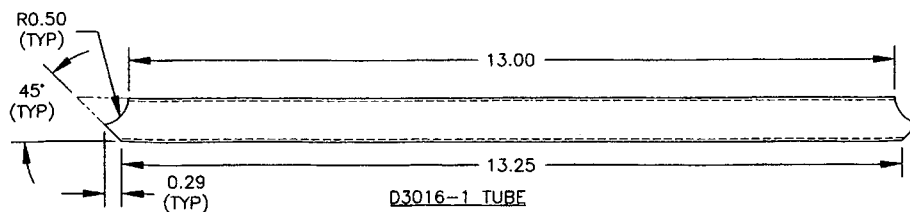
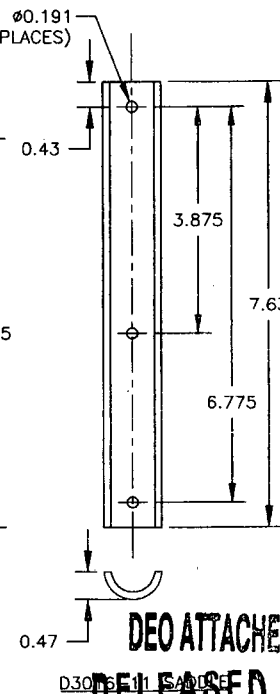
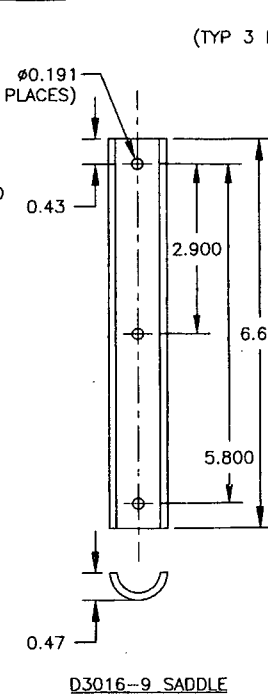
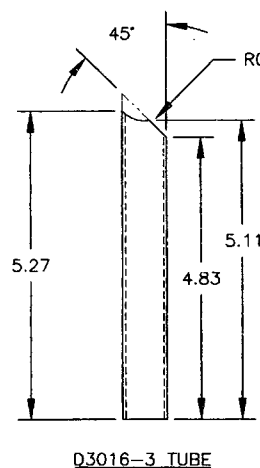
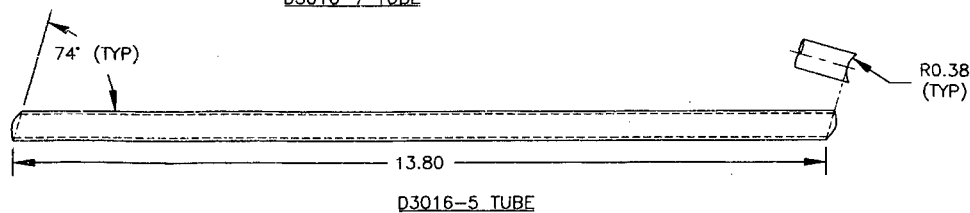
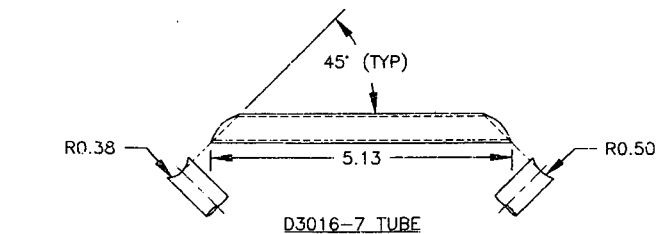
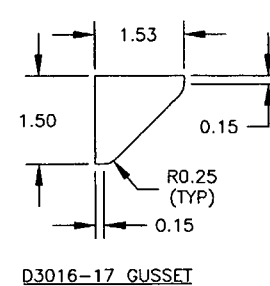
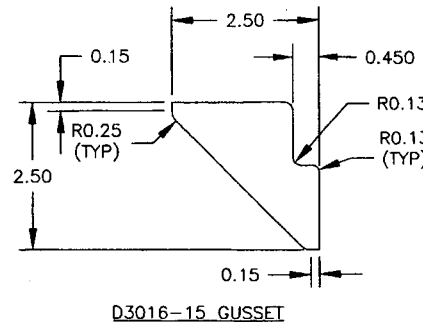
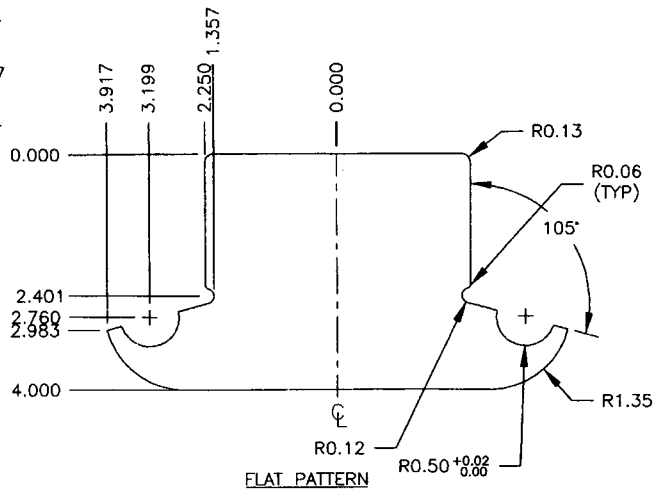
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DATE 01.05.18		TITLE SEAT FRAME ASSEMBLY		SCALE 1:3	

106749



D3016-13 BRACKET



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DESIGN CP	DRAWN BY CP	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED *	APPROVED *	DRAWING NO. D3016	REV. A SHEET 3 OF 3
DATE 01.05.18	TITLE SEAT FRAME ASSEMBLY	SCALE 1:2	

DEO ATTACHED
RELEASED
01.05.30

106749

DRAWING NO. D3016	TITLE SEAT FRAME ASSEMBLY	REV. A	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3016-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>1</i>	CHECKED <i>UP</i>	MFG. APPR. <i>RE</i>	APPROVED <i>WAP</i>	DE APPR. <i>#</i>		
DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29		

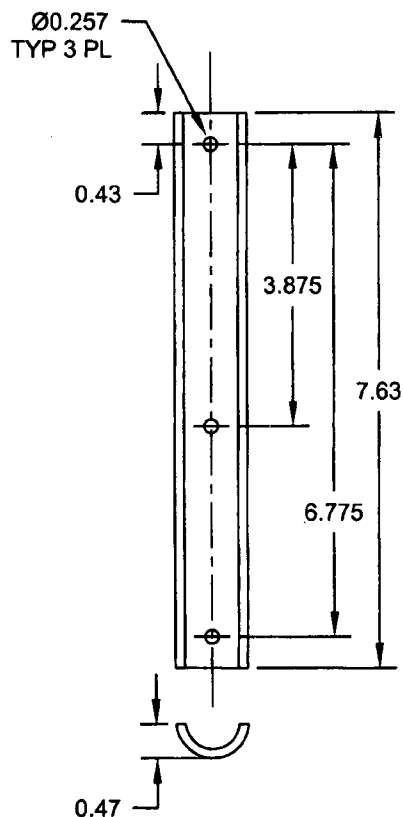
PURPOSE:

TO REVISE D3016-11 SADDLE'S HOLE SIZES

CHANGE:

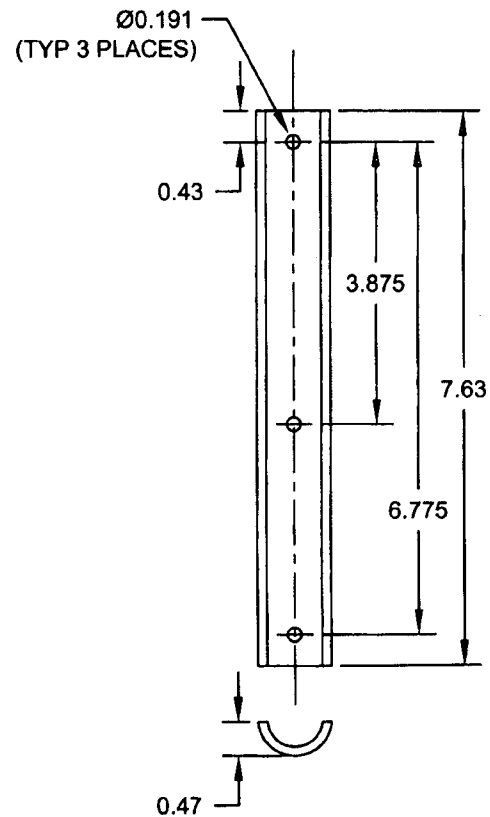
DETAIL D3016-11 SADDLE (SHEET 3): Ø0.257 TYP 3 PL WAS Ø0.191 (TYP 3 PLACES) AS SHOWN:

IS:



D3016-11 SADDLE

WAS:



D3016-11 SADDLE